



DUPLICATE

Dart Aerospace Ltd.

Date: Monday, 19/03/2007 10:12:27 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 30168		
Estimate Number	: 12117		
P.O. Number	: N/A	Part Number	: D3353041
This Issue	: 19/03/2007 S.O. No. : N/A	Drawing Number	: D3353 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 04/01/2007 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 28316	Material	: N/A
Written By	: 	Due Date	: 11/01/2007
Checked & Approved By	: 	Qty:	3.1 Um: Each
Comment	: est rev A 06.01.26 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D335311	universal joint
-----	---------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓	qty	part number	description	batch
	1	D3353-11	universal joint	330173 → 3

03.26 (3)
 Cpl 07.03.26

2.0	D33535	back plate
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓	qty	part number	description	batch
	1	D3353-5	back plate	330177

03.26 (3)
 Cpl 07.03.26

3.0	D335313	tubing
-----	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓	qty	part number	description	batch
	1	D3353-13	tubing	330174

03.26 (3)
 Cpl 07.03.26

4.0	D335317	support
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓	qty	part number	description	batch
	1	D3353-17	support	330456

03.26 (3)
 Cpl 07.03.26

Date: Monday, 19/03/2007 10:12:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 30168

Part Number: D3353041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33533

right plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description
1 D3353-3 right plate

batch

~~326804~~ → 1
~~330457~~ → 2

③

Cpl 07.03.26

6.0

D33539

STOP PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description
1 D3353-9 stop plate

batch

~~330179~~

③

Cpl 07.03.26

7.0

D33531

left plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description
1 D3353-1 left plate

batch

~~326803~~ → 2
~~330453~~ → 1

③

Cpl 07.03.26

8.0

D33537

front plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description
1 D3353-7 front plate

batch

~~330458~~

③

Cpl 07.03.26

9.0

D335315

lock bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description
1 D3353-15 lock bracket

batch

~~330455~~

③

Cpl 07.03.26

Date: Monday, 19/03/2007 10:12:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 30168

Part Number: D3353041

Job Number:



Seq. #: Machine Or Operation: Description :

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(3)

Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3353

PL 07-03-26

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

07/03/26 (3)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
1-Mask part as per dwg D3353

M 18052

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FEL

07/03/28

(3)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/29 (3)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/03/29 (3)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/30

Job Completion



U 07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

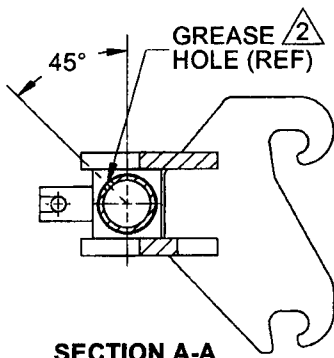
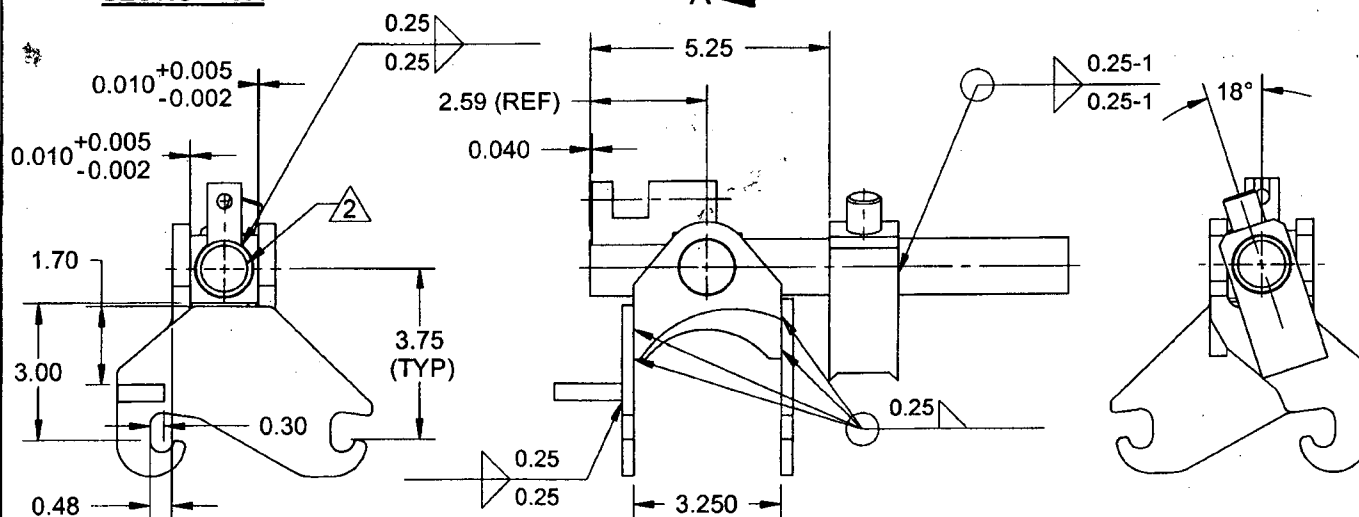
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3353	REV. A SHEET 1 OF 10
DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED
[Handwritten: 04/12/14]

D3353-15 LOCK BRACKET (1)
D3353-7 FRONT PLATE (1)
D3353-1 LEFT PLATE (1)
D3353-9 STOP PLATE (1)
D3353-11 UNIVERSAL JOINT (1)
D3353-5 BACK PLATE (1)
D3353-13 TUBING (1)
D3353-17 SUPPORT (1)
D3353-3 RIGHT PLATE (1)

**SECTION A-A****D3353-041 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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w/030168